

Date: Thursday, 3/23/2006 3:44:46 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOOR PROTECTOR FWD LH
<b>Job Number</b> : 26353	
<b>Estimate Number</b> : 11227	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D32811
<b>This Issue</b> : 3/23/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3281 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 25120	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 4/15/2006 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : [Signature] 06.03.24	
<b>Comment</b> : Est Rev:A 04.07.01 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: [Signature] FWD

Description: Floor Protector LH

Possible Supplier: Delastek

Certificate of Conformity is required

[Signature] 06/03/28

2.0	D32811P	Floor Protector, Fwd LH
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 Floor Protector, LH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure certificate of conformity is attached

[Signature] 04/4/17 (29)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

[Signature] 04-18 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: [Signature]

[Signature] 04/4/19 00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/20

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:44:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR FWD LH

Job Number: 26353

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*Handwritten:* 06/04/20 (20)

Job Completion



*Handwritten:* u 06.04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

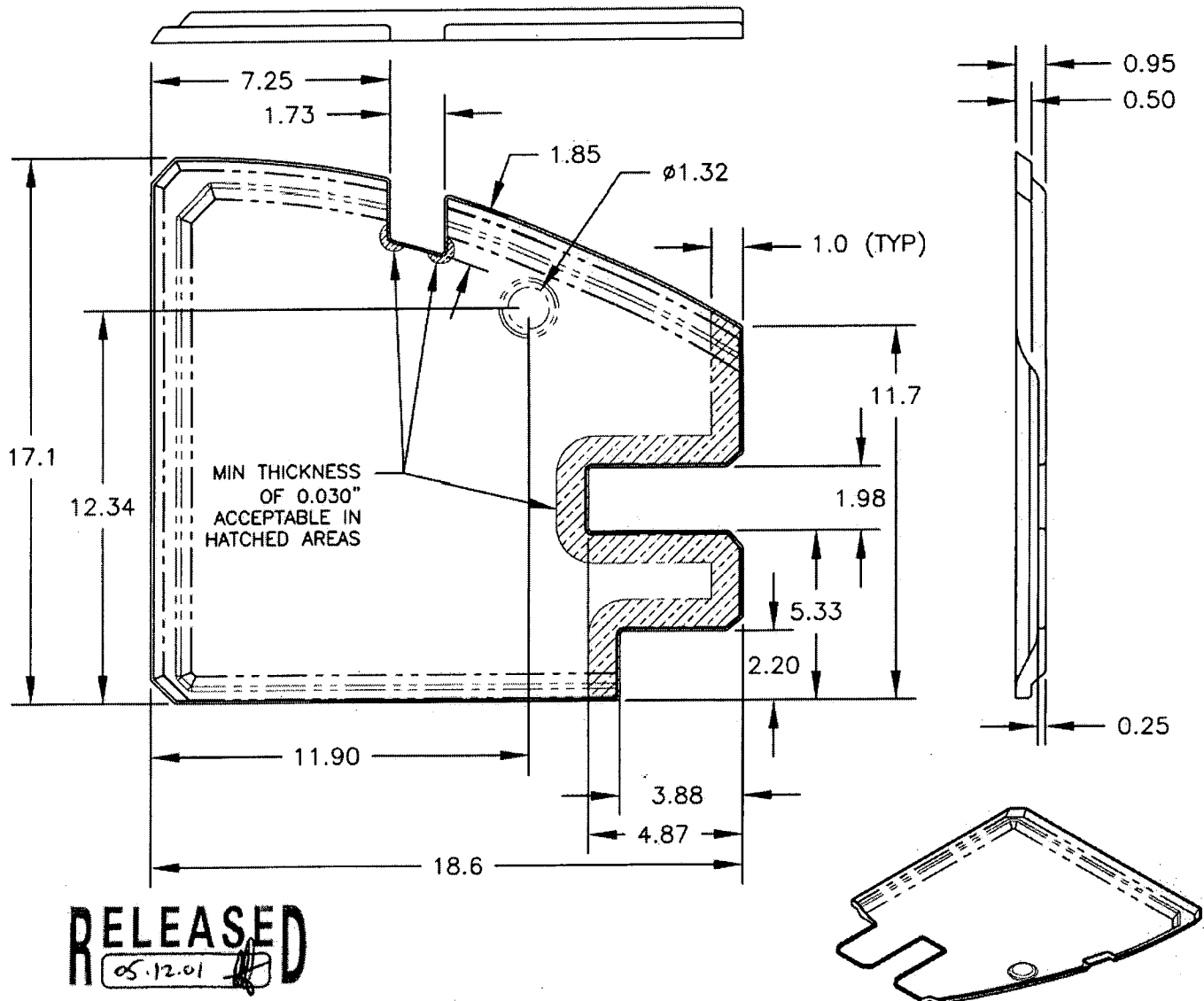
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

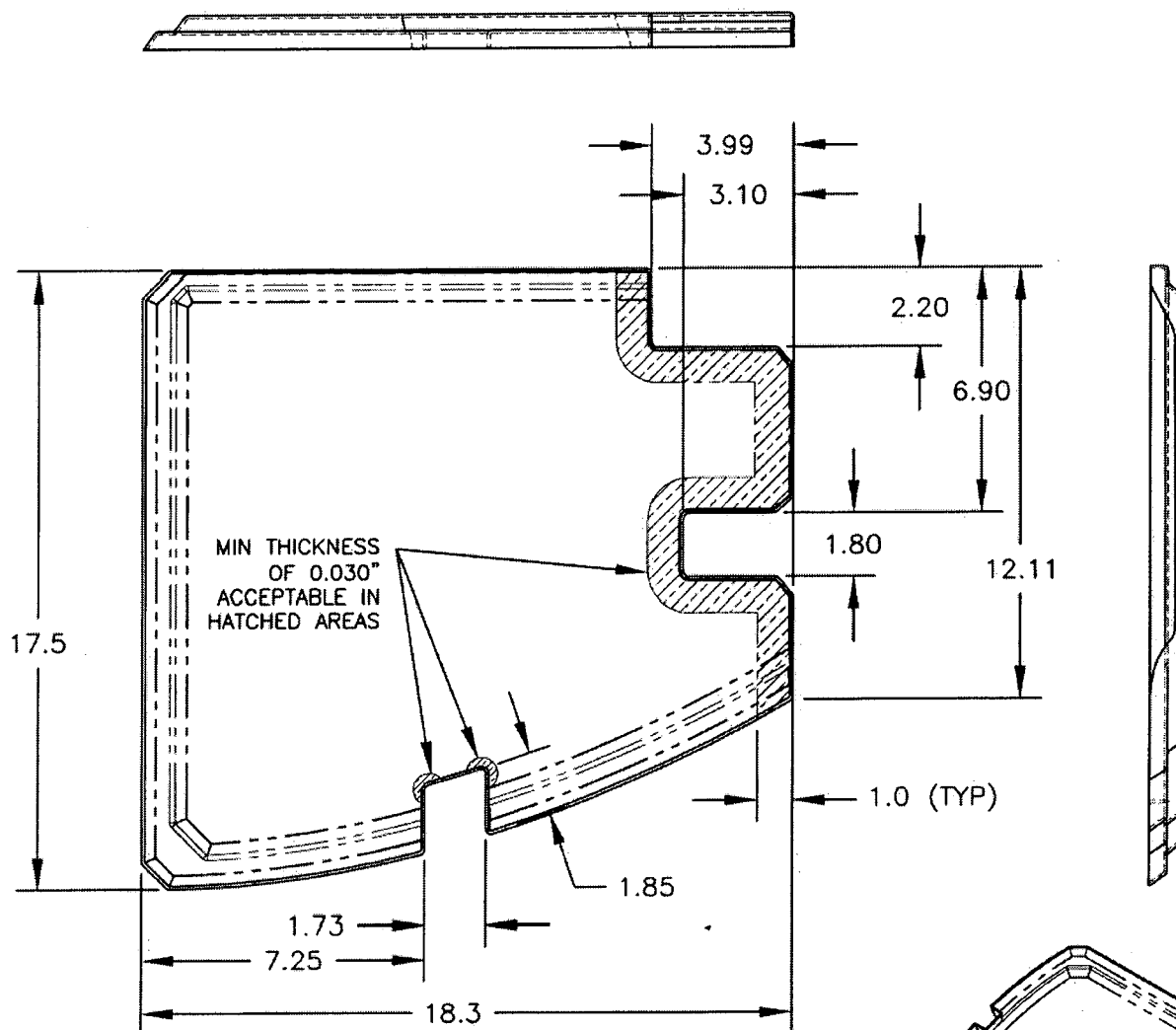
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NO. 26353

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**RELEASED**  
05.12.01 *[Signature]***D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

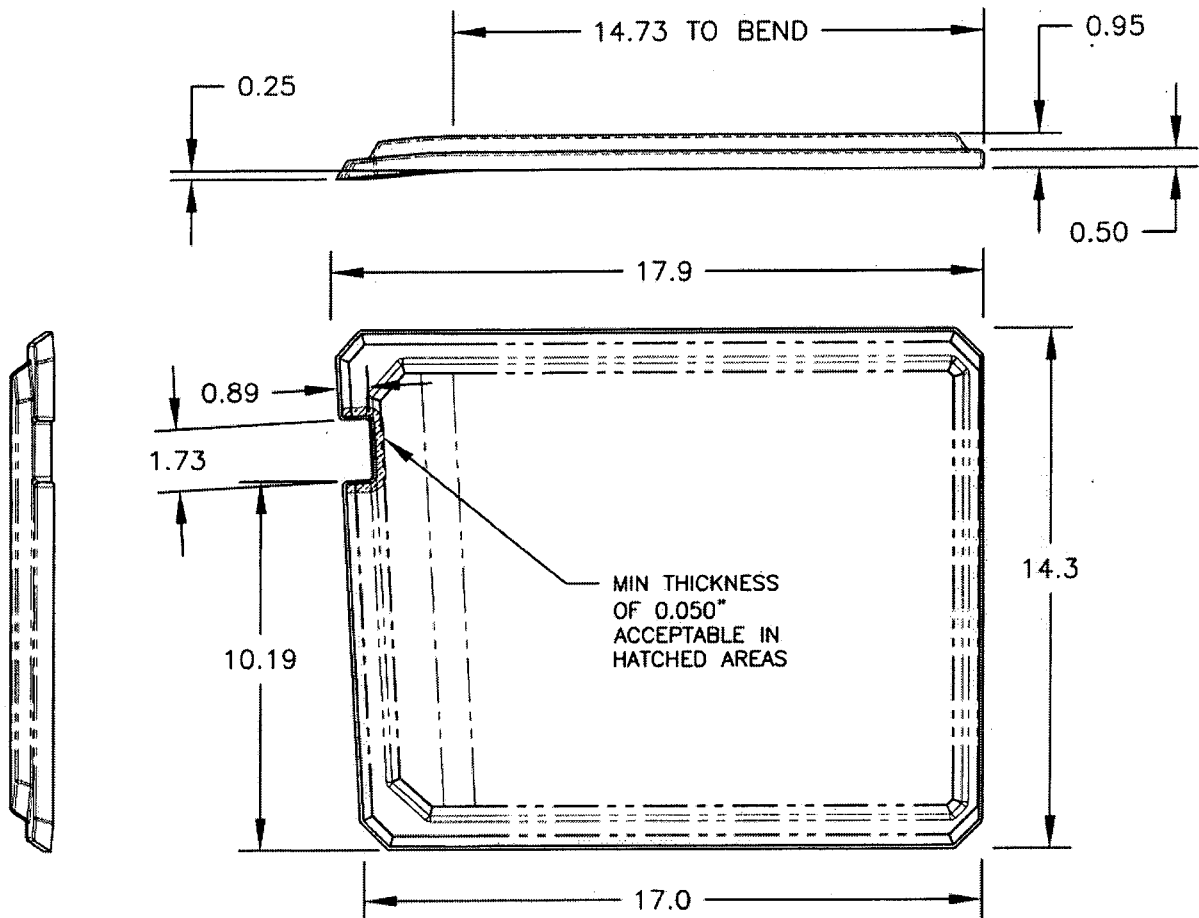
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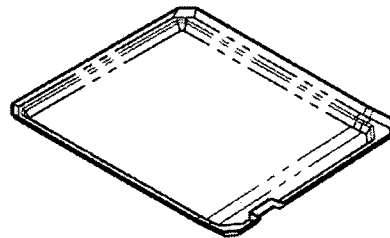
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



RELEASED  
05.12.01. *[Signature]*



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**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**  
**D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2  
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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Date: Jeudi, 2006-03-30 08:33:29  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR	
Numéro Job : 34173		Numéro Article : DKC134-0044	
Numéro Soumission : 2383		Numéro Dessin : D3281	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2006-03-30	No. B.V. :	Révision dessin : B	
Prsht Rev. : NC		Matériel : F6006	
Prem. fois : - -	Type :	Date Due : 2006-04-07	Qté: 20 UdM: UNITE
Job précédente : 32263			
Écrit par :			
Vérifié & Approuvé par :			
Commentaires : N° de pièce: D3281-1			
	Process Sheet Rév.: 00		

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 APL0016 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE(s)/Unit Total : 3.340 UNITE(s)

Lexan F6006 Noir N° 700 48" x

N° de Lot:

2.0 SÉCHAGE/ ANEAL



APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.  
# Bon achat: 5327Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs  
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

# de cuisson: 4916

3.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs  
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 20 Date: 6-4-06 Sceau:

Quantité: Date: Sceau:





## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 34173

Numéro Article: DKC134-0044

Numéro Job:



# Séq.: Machine ou Opération: Description :

4.0 THERMOFORMAGE2 THERMOFORMAGE DES PIÈCE DART

Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs  
THERMOFORMAGE DES PIECESFaire le thermoformage du " Floor Protector " N° D3281-1 à l'aide du moule N° D3281-1T1 sur le  
thermoformeur 4' x 8'.

F.O: Gauri/06

Autocontrôle du lot de pièce thermoformées.



Quantité: 20 Date: 6-4-06 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

5.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs  
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-1 à l'aide du gabarit de trimage N° D3281-1T2.

F.O: Gauri/06



Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 20 Date: 12-4-06 Sceau: L.B.

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

6.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 20 Date: 13-4-06 Sceau: \_\_\_\_\_



7.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs  
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Clien: DART Dart Aerospace Ltd.  
Numéro Job: 34173

Nom Dessin: FLOOR PROTECTOR  
Numéro Article: DKC134-0044

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

N° de pièce: D3281-1

N° de Job: \_\_\_\_\_

Date de fabrication: \_\_\_\_\_

Sceau d'inspection.

Quantité: 20 Date: 12-04-06 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en platique et ensuite mettre dans une boîte en carton  
identifiée comme suit:

N° de pièce: D3281-1

Date de fabrication: \_\_\_\_\_

N° de job: \_\_\_\_\_

Quantité: 20 Date: 13/4/06 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_